

Work Order ID 62797

October 13, 2010 1:30:21 PM



Page 1

Item ID: D4074-3

Accept



Setup Start



Revision ID:

Item Name: Channel

Stop



Start Date: 10/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4074

A

100

0.00



Waterjet

FLOW CNC Waterjet

304 .050

Memo

0.00

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

1810-10-13



(3)

1810-10-13

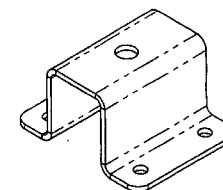
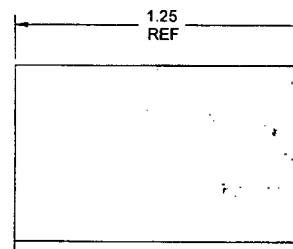
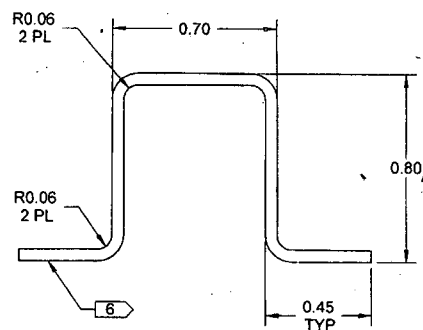
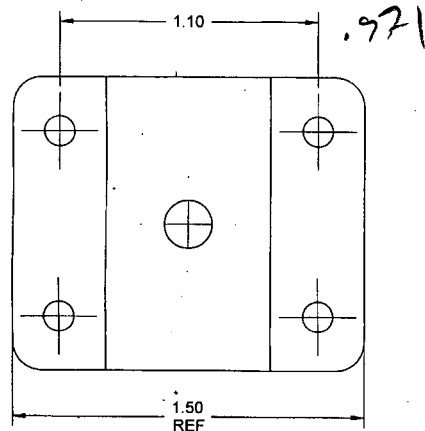
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D4074-3 CHANNEL
(MAKE FROM D4074-3F FLAT PATTERN)

W062797

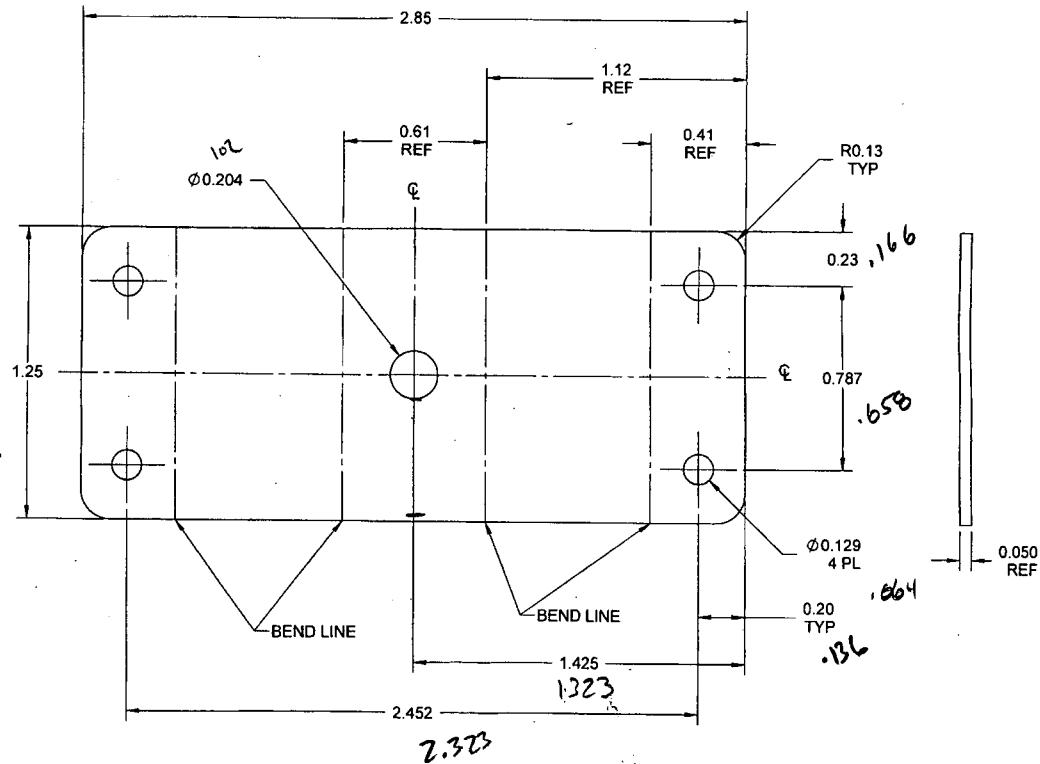
RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: MAKE FROM D4074-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

| | | | |
|------------|-----------|---|--------------|
| DESIGN | <i>RF</i> | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | <i>RF</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>RF</i> | D4074 | SHEET 3 OF 7 |
| APPROVED | <i>RF</i> | TITLE | SCALE |
| DE APPR. | <i>RF</i> | BRACKET | NTS |
| DATE | 10.09.16 | <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

GRAIN
DIRECTION



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH
0.050 (18 GAUGE) THICK
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC M3046S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

D4074-3F FLAT PATTERN

62797

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | RF | PORT HADLOCK, WA | |
| CHECKED | RF | DRAWING NO. | REV. A |
| MFG. APPR. | RF | D4074 | SHEET 4 OF 7 |
| APPROVED | RF | TITLE | SCALE |
| CE-APPR. | RF | BRACKET | 1/8" |
| DATE | 10.09.16 | COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

RELEASED
2010-09-23
JH

Receiving Report

Date: 9/2/9

Batch No: M112178

Supplier: MADNA

Dart P/O: 10030

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒
 Shipment Complete: Yes ☒ No ☒ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order 010710 N/A ☒

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|-------------|-------------|------------------|-------------------|-------------------|----------------|----------|
| D6202 | | 20 | 0 | 0 | 20 | |
| | | | | | | |
| | | | | | | |

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 09/07/13
 Date RCP 10030
 Received/Costing 68
 Initial

Location _____

Purchase Order Receipt Listing

Page 1 of 1

July 13, 2009 8:15:50 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO10030 All Receipt Dates All Line Item Types

All Item ID/GL/WOs All Rec. Employees All Currencies

Grouped by Reference (Item, WO, GL)

| Purchase Order ID | Line Nbr/ Insp Req | Project ID | Vendor ID/ Name/ Currency Type | PO U/M / Stock U/M | Req Date | Req Qty | Recv Date/ Recv Emp | Recv Qty | Cost Per Unit/ Recv Value | Inspected Qty/ Rejected Qty | MRB Qty/ MRB Reject Qty | Book Amt |
|-------------------------|--------------------|------------|--------------------------------|--------------------|--------------------|----------|---------------------|-------------------------------------|---------------------------|-----------------------------|-------------------------|----------|
| Reference: \Description | | | | M304S18GA | 304/316 .050 Sheet | 112178 | | | | | | |
| PO10030 | I | | VC-MAG002 | sf | 7/08/09 | 160.0000 | 7/13/09 | 160.0000 | \$5.00 | 0.0000 | 0 | \$800.00 |
| | No | | Magna Stainless CAD | sf | | | LAV001 | | \$800.00 | 0.0000 | 0 | |
| | | | | | | | | Total Received Quantity: | | | | 160.0000 |
| | | | | | | | | Total Quantity to Inspect (PO U/M): | | | | 0.0000 |
| | | | | | | | | Total Reject Quantity: | | | | 0.0000 |
| | | | | | | | | Total Receipt Value: | | | | \$800.00 |
| | | | | | | | | Total Balance Due Quantity: | | | | 0.0000 |



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I014049

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

STOCK

| Currency | | Sales Person | Customer Phone | Customer Fax | Customer PO | | |
|------------------|------------------------|--------------|----------------|----------------|--------------|---------------|--------------|
| CANADIAN DOLLARS | | ERYCK BLAIS | (613) 632-5200 | (613) 632-1053 | P010030 | | |
| Sales Order | Terms | | Ship Via | | Date Ordered | Date Required | Date Shipped |
| W015510 | NET 30 DAYS <i>Net</i> | | NIR:R-557065-1 | | 07/08/09 | 07/09/09 | 07/09/09 |

| Ordered | Back Ordered | Unit | Description | Bundle # | Heat # | Shipped |
|---------------|--------------|------|---|----------|---------|---------|
| 5 ✓ | | PC | STAINLESS SHEET SSH 304 2B 18ga x 48" x 96" 335 LB / 5 PC | L028387 | SC17938 | 5 |
| Total Weight: | | | | | | 335 LB |

Skids: 1

Received by: _____

Date: _____ Sign: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10030

Purchase Order Date 7/08/09

PO Print Date 7/08/09

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA



Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr 6122-5207

Terms Net 30

Currency CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

| Line Nbr | Reference Revision ID Vendor Part Number | Description/ Mfg ID | Req Date/ Taxable | Req. Qty/ Unit of Measure | Ship Method | Unit Price | Extended Price |
|----------|--|---|----------------------|------------------------------|-------------|------------|-------------------|
| 1 | M304S18GA | 304/316 .050 Sheet | 7/08/09 Yes | ✓ 160.00 sf | Yours ppd | \$5.0000 | \$800.00 |
| | | Special Inst: MATERIAL: AISI 304/316 SHEET ANNEALED 2B FINISH AS PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 | | | | | |
| 2 | D6202P A | I Beam Extrusion | 7/08/09 Yes | 20.00 f | Yours ppd | \$34.7500 | \$695.00 |

Special Inst: DESCRIPTION AMERICAN
STANDARD I-BEAM
SIZE: 4.000" X 1.796" X 0.326" THICK
MATERIAL: 6061-T6 / T651 AS PER
QQ-A-200/8
MINIMUM ULTIMATE TENSILE
STRENGTH = 38 KSI
MINIMUM YIELD TENSILE
STRENGTH = 35 KSI

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PO Total: \$1,495.00

Change Nbr: 2

Change Date: 7/08/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

POSCO Mill Test Certificate/검사증명서 MO7117

Certificate No./증명서번호: 080910-PRSE-010-001
Date of Issue/발행일자: Sep. 16, 2008
Surface Finish/표면마무리: NO.2B

Order No./계약번호: 0003353485

PO No./주문번호: 3353485

Supplier/주요자: DAE WOO INTERNATIONAL CORP.

Commodity/품명: STAINLESS COLD ROLLED COIL

Customer/고객: MAGNA STAINLESS INC.

Spec. & Type/규격: ASTM-A240-304

| Size/치수 | Product No./제품번호 | Quantity/수량 | Weight/중량 (kg) | Heat No./재질번호 | P.O.S.T. MARK | Tensile/인장시험 YS 0.2% TS EL (MPa) (%) | Hardness/경도 HRB | Chemical Composition/화합성분 (%) C Si Mn P S Cr Ni Cu Mo N |
|-----------------|------------------|-------------|----------------|---------------|---------------|--|--------------------|--|
| 0.90x1219x6 | QEH0799A | 1 | 4,677 | SE37926 | T | 266 643 60 | 82.6 | C: 0.030 Si: 0.030 Mn: 0.030 P: 0.005 S: 0.005 Cr: 18.10 Ni: 8.00 Cu: 0.030 Mo: 0.030 N: 0.010 |
| 0.90x1219x6 | QEH0799B | 1 | 4,677 | SE37926 | B | 277 649 60 | 83.5 | C: 0.030 Si: 0.030 Mn: 0.030 P: 0.005 S: 0.005 Cr: 18.10 Ni: 8.00 Cu: 0.030 Mo: 0.030 N: 0.010 |
| Sub Total (010) | | 2 | 9,354 | | | 9,354 (kg) | | |
| 1.20x1219x6 | QEH0031B | 1 | 5,649 | SC17938 | T | 281 651 60 | 82.3 | C: 0.030 Si: 0.030 Mn: 0.030 P: 0.005 S: 0.005 Cr: 18.10 Ni: 8.00 Cu: 0.030 Mo: 0.030 N: 0.010 |
| 1.20x1219x6 | QEH0031C | 1 | 4,150 | SC17938 | B | 288 663 59 | 84.7 | C: 0.030 Si: 0.030 Mn: 0.030 P: 0.005 S: 0.005 Cr: 18.10 Ni: 8.00 Cu: 0.030 Mo: 0.030 N: 0.010 |
| 1.20x1219x6 | QEH0031D | 1 | 6,546 | SC17938 | T | 288 663 59 | 84.7 | C: 0.030 Si: 0.030 Mn: 0.030 P: 0.005 S: 0.005 Cr: 18.10 Ni: 8.00 Cu: 0.030 Mo: 0.030 N: 0.010 |
| Sub Total (020) | | 3 | 16,345 | | | 16,345 (kg) | | |
| 1.50x1219x6 | QEH0030A | 1 | 5,369 | SC17797 | T | 285 643 58 | 83.7 | C: 0.030 Si: 0.030 Mn: 0.030 P: 0.005 S: 0.005 Cr: 18.02 Ni: 8.03 Cu: 0.030 Mo: 0.030 N: 0.010 |
| 1.50x1219x6 | QEH0030B | 1 | 5,379 | SC17797 | B | 287 648 58 | 86.0 | C: 0.030 Si: 0.030 Mn: 0.030 P: 0.005 S: 0.005 Cr: 18.02 Ni: 8.03 Cu: 0.030 Mo: 0.030 N: 0.010 |
| 1.50x1219x6 | QEH0030C | 1 | 5,225 | SC17797 | T | 285 643 58 | 83.7 | C: 0.030 Si: 0.030 Mn: 0.030 P: 0.005 S: 0.005 Cr: 18.02 Ni: 8.03 Cu: 0.030 Mo: 0.030 N: 0.010 |
| Sub Total (030) | | 3 | 15,973 | | | 15,973 (kg) | | |

Position: T: Top, M: Middle, B: Bottom
Tensile Test: Direction: Transversal, Gauge Length: 50mm (Rectangular)
YP Method: 0.2% off-set
Dispos: L: Ladle Analysis
Chemical Composition Unit: 2x1/100, 3x1/1000, 4x1/10000, 5x1/100000
Tr: It is within the standard range (<0.008%) and include trace element.

We hereby certify that the material herein has been made in accordance with the order and specification.

Test Certificate is issued according to EN10204 3.1B.
This Mill Test Certificate cannot be copied for any purpose.

Surveyor To:

POSCO Pohang Works, 5 Dongchon-dong, Nam-gu, Pohang-si, Gyeongsangbuk-do, 790-785, Korea

Chief of material testing section Jo, Won (

RUSH

CE

NOTE SHEET

DART
aerospace

Project # 00267

Part#: D3849-047

Description: Wearplate ass'y

If item not required write N/A in "responsible" column

| Item | Action required | Responsible | Due Date | Done by / Date |
|------|--|----------------|----------|----------------|
| 1 | m304S18GA 0.050" thick Batch: XXXXXXXXXX Cut D3849-7 as per dwg | X 128 SF magna | | |
| 2 | M-NEO60-S.063 black neo 0.063" batch: _____ Cut D3848-7 as per dwg | | | |
| 3 | M304B0.500X2500 SS bar Batch: _____ Cut D3901-1 as per dwg | | | |
| 4 | Bend wearplate as per dwg | | | |
| 5 | Weld as per dwg D3849 | | | |
| 6 | QC 9 / QC 5 | | | |
| 7 | Powdercoat gray sandtex per QSI 005 | | | |
| 8 | QC 3 | | | |
| 9 | Bond gasket as per dwg | | | |
| 10 | QC 5 | | | |
| 11 | Identify and Stock | | | |
| 12 | | | | |
| 13 | | | | |